



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2573
Job Sheet 179310



Part No: D2573

Job Qty: 8 ea

Part Name: Saddle, Aft, Out



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/16/18

Job Tracking No:

Due Date: 7/6/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV F IPP: I As Per RevE 06-01-27 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea		7/6/18	0.00	0.00	Start Up Machining		SBL 18/07/20
100	CNC Vertical Machining	8 pcs		7/6/18	1.01	13.33	HAAS 1		SBL 18/07/20
110	Mill Conv	8 pcs		7/6/18	0.00	1.33	Mill Conv 1		SBL 18/07/20
130	QC	8 pcs		7/6/18	0.00	0.00	QC8		SA 18-07-30
140	HandFinish	8 pcs		7/6/18	0.00	0.38	HandFinish1		SA 18-07-30
150	Powdercoat	8 pcs		7/6/18	0.00	0.31	Powdercoat1		SA 18-07-30
160	QC	8 pcs		7/6/18	0.00	0.00	QC3		AUG 20 2018
170	Packaging	8 pcs		7/6/18	0.00	0.00	Packaging3		AUG 23 2018
180	QC21-SA	8 Ea		7/6/18	0.00	0.00	QC21		AUG 24 2018

Part Op 100 - Program Batch No. SC94534

Descriptions: 110 - Machine keyway as per dwg D2573 & D2574

150 - START TIME: 10:45am 11:15am 320°

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	8 Ea (1 ea)	90-Start up Operation	SC66608

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-007	8	45	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Aft Outboard	0.438Inches + 0.005 - 0.000	0.443 0.438		
2	Saddle, Aft Outboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
3	Saddle, Aft Outboard	3.495Inches + 0.010 - 0.000	3.505 3.495		
4	Saddle, Aft Outboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
5	Saddle, Aft Outboard	7.990Inches + 0.020 - 0.000	8.010 7.990		

Work Order update only

Positioned Wrong
Outside Dimensions
Over/Under tolerances
Part Incorrect
Part Lost/Missing
Part Moved
Drawing
Finish
Mistread
Turning Sequence

6	Saddle, Aft Outboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
7	Saddle, Aft Outboard	0.257Inches	+ 0.005 - 0.000	0.262 0.257
8	Saddle, Aft Outboard	0.375Inches	+ 0.005 - 0.000	0.380 0.375
9	Saddle, Aft Outboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
10	Saddle, Aft Outboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
11	Saddle, Aft Outboard	0.558Inches	+ 0.020 - 0.000	0.578 0.558
12	Saddle, Aft Outboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
13	Saddle, Aft Outboard	1.365Inches	+ 0.010 - 0.000	1.375 1.365
14	Saddle, Aft Outboard	2.495Inches	+ 0.010 - 0.000	2.505 2.495
15	Saddle, Aft Outboard	4.119Inches	+ 0.010 - 0.000	4.129 4.119
16	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
17	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
18	Saddle, Aft Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
19	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Aft Outboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Aft Outboard	3.210Inches	+ 0.040 - 0.000	3.250 3.210
22	Saddle, Aft Outboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Aft Outboard	0.308Inches	+ 0.005 - 0.000	0.313 0.308
25	Saddle, Aft Outboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Aft Outboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Aft Outboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Aft Outboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Aft Outboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Aft Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Aft Outboard	1.500Inches	+ 0.020 - 0.000	1.520 1.500
32	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Aft Outboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Aft Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Aft Outboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000
36	Saddle, Aft Outboard	0.023Inches	+ 0.020 - 0.000	0.043 0.023

DART AEROSPACE LTD	Work Order: 179 310
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.002	8.002	8.002		
F	0.490	0.510		.503	.503	.501	.500		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.501	.501	.501	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.569	.568	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.125	4.124		
P	0.115	0.135		.133	.125	.133	.133		
Q	0.115	0.135		.124	.124	.124	.124		
R	0.240	0.260		.251	.251	.251	.251		
S	0.115	0.135		.130	.128	.126	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.232	3.230	3.230	3.230		
V	0.230	0.250		.240	.240	.240	.240		
W	0.115	0.135		.128	.124	.124	.126		
X	0.308	0.313		.312	.312	.312	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.367	.365	.367	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.629	.627	.627	.626		
AC	0.053	0.073		.063	.061	.062	.062		
AD	0.240	0.260		.251	.250	.250	.249		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		.120	.128	.120	.125		
AG	0.240	0.280		.270	.270	.265	.265		
AH	0.240	0.260		.245	.244	.245	.248		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

DAS

Measured by:	57
Date:	9-89 18/07/21

Audited by:	[Signature]
Date:	18/07/30

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 179 310
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5 *	6 *	7 *	8 *		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.002	8.002	8.002		
F	0.490	0.510		.499	.495	.502	.494		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.500	.500	.501	.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.508	.508	.509	.506		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.133	.133	.130	.133		
Q	0.115	0.135		.124	.125	.124	.124		
R	0.240	0.260		.252	.252	.252	.252		
S	0.115	0.135		.126	.125	.121	.124		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.240	.240	.240	.240		
W	0.115	0.135		.126	.124	.125	.127		
X	0.308	0.313		.312	.311	.311	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.365	.366	.367	.367		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.627	.627	.627		
AC	0.053	0.073		.062	.060	.061	.060		
AD	0.240	0.260		.251	.250	.250	.251		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		.122	.130	.130	.130		
AG	0.240	0.280		.265	.265	.265	.265		
AH	0.240	0.260		.248	.249	.248	.246		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by: 57
Date: 9-89 18/07/23

Audited by: [Signature]
Date: 18/07/23

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	